



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001
Job Sheet 184034



805898

Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No: SIOP

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Stores/Pkg-1		OCT 15 2018
110	Packaging	1 pcs	11/2/18	11/2/18	0.00	0.00	Packaging1-1		OCT 15 2018
120	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC4		NOV 05 2018
130	Packaging	1 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1		NOV 05 2018
135	DC	1 pcs	11/2/18	11/2/18	0.00	0.00	DC		NOV 05 2018
140	QC21-FG	1 Ea	11/2/18	11/2/18	0.00	0.00	QC21		NOV 05 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5031229
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	50783313
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	50791324
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	50753224
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5066988
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5111223
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5059056
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5091495
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5079963
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5050458
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5092525
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049669
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5063766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5038792
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5035990
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5050290
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5038801
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5064802



Container No: S118344



Part: 646.4001

Job No: 184034

Serial No/Batch: S118344

Revision:

Inspector:

Exp Date: 03/14/2019

Instructions: FAA STC SR02180LA 08/12/16, TC STC SH09 -

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503.84034 #1

646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5063754
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5067214
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5057883
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5067236
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5037064
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5083586
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5083591
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5041498
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056998
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5063624
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5055599
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5092170
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5078165x9
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5048376x1
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5098032
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5056460
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5060063
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095480
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080632
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5065262
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5065264
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5071733
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5074204
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	F153488
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	FM134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	F124089
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	F123425
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5100409
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5094592
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5094597
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5103943
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5064859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5080642
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5050050
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5071834
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5006971
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5115626
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5071413
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5000680
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5037684
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5103666
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5025330
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5083558
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5100408

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	280	0
	600.0990	1	12	0
	600.0991	1	12	0
	600.1012	1	14	0
	600.1013	5	34	0
	646.2910	1	27	0
	646.3001	1	5	0
	646.3110	1	3	0
	646.3210	1	16	0
	646.3301	1	8	0
	646.3510	1	19	0

646.3511	1	24	0
646.3610	1	24	0
646.3710	1	50	0
646.3711	1	34	0
646.3712	1	22	0
646.3713	1	17	0
646.3714	1	23	0
646.3715	2	33	0
646.3716	1	40	0
646.3717	1	26	0
646.3718	2	44	0
646.3719	2	36	0
646.3810	2	8	0
646.3811	1	31	0
646.3812	2	2	0
646.3813	1	13	0
646.3910	4	33	0
646.3911	1	23	0
646.3912	4	30	0
646.3913	1	39	0
646.9410	1	101	0
647.0112	2	108	0
647.7703	2	1	0
650.9201	2	17	0
AN3-11A	10	219	0
AN3-12A	2	108	0
AN3-13A	1	103	0
AN3-3A	4	293	0
AN3-4A	10	431	0
AN3-5A	2	290	0
AN3-6A	2	206	0
AN316C4R	2	43	0
AN44-5A	2	33	0
AN4C7A	2	149	0
AN665-34R	2	35	0
CCR264SS3-02	36	429	0
CR3213-5-3	14	286	0
MS20426AD5-7	2	1,061	0
MS20470AD5-5.5	8	237	0
MS20470AD5-6	8	1,022	0
MS20470AD5-7	3	146	0
MS21042L08	2	2,540	0
MS21042L3	63	3,017	0
MS21042L4	2	3,955	0
MS21047-3	18	536	0
MS24693-C278	5	154	0
MS24694-S51	5	123	0
MS24694-S54	2	36	0
MS24694-S55	3	204	0
MS27039-08-13	2	197	0
MS27039-1-10	2	214	0
MS27039-1-12	6	123	0
MS27039-1-16	24	543	0
MS27039-1-19	22	277	0
MS27039-1-20	2	117	0
MS27039-1-21	4	122	0
NAS1149F0332P	144	3,011	0
NAS1149F0363P	2	586	0
NAS1149F0432P	4	1,226	0
NAS1149FN832P	4	3,526	0

Part Specifications

Specifications could not be found.

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NOTES:

- 1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.
- 2 INSTALL F/N 14 WITH F/N 52 & 53.
- 3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.
- 4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.
- 5 REUSE FASTENERS FROM F/N 1.
- 6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.
- 7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.
- 8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.
- 9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	AS1149F03M3P	
1	1	1	77	646.9410	SHIM	AS1149F03M3P	
		4	76	601.2764	WASHER	AS1149F03M3P	
		2	75	601.2973	LOCKNUT	MS21042-08	
		2	74	601.2988	SCREW	MS27039-0813	
		2	73	601.2943	LOCKNUT	MS21042-08	
		2	72	601.3128	NUT	AN316CAR	
		2	71	601.3209	LOCKNUT	MS21042-08	
		4	70	601.2638	WASHER	AS1149F03M3P	
		2	69	601.2669	BOLT	AN4C7A	
		2	68	601.3119	CLEVIS	AN465-348	
		2	67	601.3121	EYE BOLT	AN44-5A	
		2	66	650.9201	EYE BRACKET ASSY		
	REF	REF	65	647.5701	GPS MOUNT KIT		
		2	64	601.3151	WASHER	AS1149F03M3P	
		2	63	601.2911	SCREW	MS24694553	
		24	62	601.2637	SCREW	MS27039-1-16	
2		2	61	601.2763	BOLT	AN3-12A	
		1	60	646.3913	SHIM		
		4	59	646.3912	SHIM		
		1	58	646.3911	SHIM		
		4	57	646.3910	SHIM		
		5	56	600.1013	PRIMER		
	8 FT	8 FT	55	600.0129	VHB TAPE		
		1	54	600.1012	SEALANT	FR-105 CLASS B	
		1	53	600.0991	MAGNOBOND 639B PART B		
		1	52	600.0990	MAGNOBOND 639B PART A		
6	10	10	51	601.2826	BOLT	AN3-11A	
		2	50	646.3814	WIPER BRACKET		
		2	49	601.2910	SCREW	MS27039-1-18	
		2	48	601.1365	SCREW	MS27039-1-10	
		2	47	646.3719	DOUBLER		
		2	46	646.3718	CUSTOM WASHER		
		1	45	646.3717	DOUBLER		
		22	44	601.1948	SCREW	MS27039-1-19	
		2	43	601.1952	SCREW	MS27039-1-20	
		4	42	601.1956	SCREW	MS27039-1-21	
4006	4005	4004	4003	4002	4001	FIND #	PART #
							DESCRIPTION
							MATL
							SPEC.

REVISIONS							
REV	DESCRIPTION	DATE	APPROVED	REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02099, 02081, 02716 & 02745	03/26/2010	P. BRAVO	1	601.2829	SCREW	MS24694554
B	INCORPORATED ECN 02046, 02079 & 04731	11/04/2014	P. BRAVO	2	601.2831	RIVET	MS20426AD5-7
C	INCORPORATED ECN 03098	09/09/2018	P. BRAVO	3	646.3716	GAUGE BRACKET	
				6	601.1953	SCREW	MS27039-1-12
				2	646.3715	STRUT DOUBLER	
				2	601.2824	BOLT	AN3-5A
12	36	36	35	601.2277	RIVET	CCW4485-3-02	
6	18	18	34	600.0795	NUTPLATE	MS21047-3	
3	3	3	33	601.2565	RIVET	MS20470AD5-7	
1	1	1	32	646.3813	STRUT BRACKET		
4	4	4	31	601.2822	BOLT	AN3-3A	
2	2	2	30	646.3812	GUSSET BRACKET		
6	8	8	29	601.2564	RIVET	MS20470AD5-6	
1	1	1	28	646.3714	GUSSET		
	1	1	27	646.3810	FILLER		
3	3	3	26	601.2830	SCREW	MS24694555	
2	2	2	25	601.2825	BOLT	AN3-5A	
1	1	1	24	646.3811	RADIUS BLOCK		
1	1	1	23	646.3712	CLIP		
1	1	1	22	646.3711	CLIP		
8	8	8	21	601.2832	RIVET	MS20470AD5-6-1	
14	14	14	20	601.2020	RIVET	CR3213-5-3	
4	6	4	19	601.2823	BOLT	AN3-4A	
	1	1	18	601.2827	BOLT	AN3-13A	
5	5	5	17	601.2912	SCREW	MS24694551	
1	1	1	16	646.3713	GUSSET		
1	1	1	15	646.3210	SUPPORT		
	1	1	14	646.3710	DOUBLER		
1	1	1	13	646.3110	CHANNEL		
14	10	8	12	601.1624	LOCKNUT	MS21042-13	
16	32	18	11	601.1607	WASHER	AS1149F0322P	
			10	646.3410	LH WIPER DEFLECTOR		
			9	646.3411	RH WIPER DEFLECTOR		
		2	8	647.7708	STRUT ASSY		
		2	7	647.0112	STRUT BRACKET		
1	1	1	6	646.3511	STRUT		
1	1	1	5	646.3510	STRUT		
2	2	2	4	646.3810	BRACKET		
		1	3	646.2910	DEFLECTOR		
1	1	1	2	646.3001	LOWER CUTTER ASSY		
		1	1	646.3301	UPPER CUTTER ASSY		
X				646.4006	LOWER CUTTER TYPED PROVISIONS		
	X			646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
		X		646.4004	FIXED PROVISIONS KIT		
			X	646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS		
				646.4002	AS350 WIPER DEFLECTOR KIT		
			X	646.4001	AS350 CABLE CUTTERS KIT		
4006	4005	4004	4003	4002	4001	FIND #	PART #
							DESCRIPTION
							MATL
							SPEC.

QTY	NEXT ASSY (S)	ORIGINAL DATE 10/01/08	DATE 08/27/08
		DRAWN BY S. HUFF	CHECKED BY P. BRAVO
		DRAWING APPROVAL P. BRAVO	DESIGNER P. BRAVO
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°	
		SIZE B	
		REV C	

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DART
AEROSPACE
APICAL INDUSTRIES INC.
DBA DART AEROSPACE

AS350 CABLE CUTTERS KIT

REV NO
646.4000

SCALE NONE

SHEET 1 OF 5

